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This listing of claims replaces all prior versions, and listings, of claims in this application.

**Listing of Claims:**

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41. (Original) A method for shaping web materials comprising the steps of:

- (a) feeding a web material between a rotary die and an anvil roller, wherein the rotary die and the anvil roller are rotating in opposite directions;
- (b) cutting the web material with the rotary die into a web product and a web flash;
- (c) conveying the web product away from the anvil roller; and
- (d) removing the web flash for recycling.

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42. (Original) The method of claim 41, wherein the step of feeding a web material comprises conveying the web material on a vacuum belt.

43. (Original) The method of claim 41, wherein the step of conveying the web product away comprises conveying the web product on a vacuum belt.

44. (Original) The method of claim 41, wherein the step of removing the web flash comprises conveying the web flash on a belt.

45. (Original) The method of claim 41, wherein the step of removing the web flash further comprises applying lubricant to the rotary die to ease removal of the web flash from the rotary die.

46. (Original) The method of claim 41, wherein the web material comprises more than one layer and the anvil roller is configured to produce a kiss-cut, wherein the rotary die cuts only one layer of the web material.

47. (Original) The method of claim 46, wherein the web material comprises a product layer and a liner, and wherein the rotary die cuts only the product layer into the web product and the web flash.

48. (Original) The method of claim 47, wherein the product layer comprises at least one mastic and the liner comprises at least one member selected from the group consisting of paper, polyethylene, polyester, aluminum foil, brass foil, and copper foil.

49. (Original) The method of claim 47, wherein the product layer comprises rubber butyl based mastic and the liner comprises rubber butyl web.

50. (Original) The method of claim 41, wherein the anvil roller is configured to produce a through-cut.

51. (Original) The method of claim 41, further comprising the steps of:

- (e) adhering the web product to the rotary die;
- (f) rotating the web product around the rotary die to the bottom of the rotary die;
- (g) feeding a primary web material between the rotary die and a second anvil roller,

wherein the rotary die and the second anvil roller are rotating in opposite directions;

(h) joining the web product and the primary web material at a location between the rotary die and the second anvil roller;

(i) cutting the primary web material with the rotary die into a primary web product and a primary web flash, wherein the primary web product is equal in size and shape to the web product and is attached to the web product to form a final product;

(j) conveying the final product away from the rotary die and the second anvil roller;  
and

(k) removing the primary web flash for recycling.

52. (Original) The method of claim 51, wherein the step of feeding the primary web material comprises conveying the primary web material on a vacuum belt.

53. (Original) The method of claim 51, wherein the step of conveying the final product away comprises conveying the final product away on a vacuum belt.

54. (Original) The method of claim 51, wherein the step of removing the web flash comprises conveying the web flash on a belt.

55. (Original) The method of claim 51, wherein the step of removing the web flash comprises vacuuming the web flash off of the anvil roller.

56. (Original) The method of claim 51, wherein the step of removing the primary web flash comprises conveying the primary web flash on a belt.

57. (Original) The method of claim 51, wherein the step of removing the web flash further comprises applying lubricant to the rotary die to ease removal of the web flash from the rotary die.

58. (Original) The method of claim 51, wherein the step of removing the primary web flash further comprises applying lubricant to the rotary die to ease removal of the primary web flash from the rotary die.

59. (Original) The method of claim 51, wherein the step of adhering the web product to the rotary die comprises applying a vacuum through the rotary die.

60. (Original) The method of claim 51, wherein the step of adhering the web product to the rotary die comprises applying temporary adhesive to the rotary die.

61. (Original) The method of claim 51, wherein the web material comprises one of a mastic, a polyethylene, a polyester, and a metal foil, and wherein the primary web material comprises one of a mastic, a polyethylene, a polyester, and a metal foil.

62. (Original) The method of claim 41, wherein the rotary die and the anvil roller are mounted on a lifting mechanism, wherein a second rotary die and a second anvil roller are mounted on a second lifting mechanism in a raised position, and wherein the method further comprises the steps of:

- (e) lifting the rotary die and the anvil roller out of service;
- (f) lowering the second rotary die and the second anvil roller;
- (g) feeding additional web material between the second rotary die and the second anvil roller, wherein the second rotary die and the second anvil roller are rotating in opposite directions;
- (h) cutting the additional web material with the second rotary die and the second anvil roller into additional web product and additional web flash;
- (i) conveying the additional web product away from the second rotary die and the second anvil roller; and
- (j) removing the additional web flash for recycling.

63. (Original) The method of claim 51, wherein the rotary die, the anvil roller, and the second anvil roller are mounted as a first assembly on a lifting mechanism, wherein a second assembly including a second rotary die, a third anvil roller, and a fourth anvil roller is mounted on a second lifting mechanism in a raised position, and wherein the method further comprises the steps of:

- (l) lifting the first assembly out of service;
- (m) lowering the second assembly; and
- (n) repeating steps (a) through (k) using the second assembly.

64. (Original) A method for laminating a primary web material and a secondary web material comprising the steps of:

(a) feeding the secondary web material between a rotary die and a first anvil roller, wherein the rotary die and the first anvil roller are rotating in opposite directions;

(b) cutting the secondary web material with the rotary die into a secondary web product and a secondary web flash;

(c) removing the secondary web flash for recycling;

(d) adhering the secondary web product to the rotary die;

(e) rotating the secondary web product around the rotary die to the bottom of the rotary die;

(f) feeding the primary web material between the rotary die and a second anvil roller, wherein the rotary die and the second anvil roller are rotating in opposite directions;

(g) joining the secondary web product and the primary web material at a location between the rotary die and the second anvil roller;

(h) cutting the primary web material with the rotary die into a primary web product and a primary web flash, wherein the primary web product is equal in size and shape to the secondary web product and is attached to the secondary web product to form a final product;

(i) conveying the final product away from the rotary die and the second anvil roller;  
and

(j) removing the primary web flash for recycling.

65. (Original) The method of claim 64, wherein the step of feeding the primary web material comprises conveying the primary web material on a vacuum belt.

66. (Original) The method of claim 64, wherein the step of conveying the final product away comprises conveying the final product away on a vacuum belt.

67. (Original) The method of claim 64, wherein the step of removing the secondary web flash comprises conveying the secondary web flash on a belt.



68. (Original) The method of claim 64, wherein the step of removing the secondary web flash comprises vacuuming the secondary web flash off of the first anvil roller.

69. (Original) The method of claim 64, wherein the step of removing the primary web flash comprises conveying the primary web flash on a belt.

70. (Original) The method of claim 64, wherein the step of removing the secondary web flash further comprises applying lubricant to the rotary die to ease removal of the secondary web flash from the rotary die.

71. (Original) The method of claim 64, wherein the step of removing the primary web flash further comprises applying lubricant to the rotary die to ease removal of the primary web flash from the rotary die.

72. (Original) The method of claim 64, wherein the step of adhering the secondary web product to the rotary die comprises applying a vacuum through the rotary die.

73. (Original) The method of claim 64, wherein the step of adhering the web product to the rotary die comprises applying temporary adhesive to the rotary die.

74. (Original) The method of claim 64, wherein the step of cutting the primary web material further comprises pressing the secondary web product onto the primary web product using foam of the rotary die.

75. (Original) The method of claim 64, wherein the rotary die, the first anvil roller, and the second anvil roller are mounted as a first assembly on a lifting mechanism, wherein a second assembly including a second rotary die, a third anvil roller, and a fourth anvil roller is mounted on a second lifting mechanism in a raised position, and wherein the method further comprises the steps of:

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- (k) lifting the first assembly out of service;
  - (l) lowering the second assembly; and
  - (m) repeating steps (a) through (j) using the second assembly.

76. (Original) The method of claim 64, wherein the primary web material comprises at least one member selected from the group consisting of a mastic, a polyethylene, a polyester, and a metal foil, and wherein the secondary web material comprises at least one member selected from the group consisting of a mastic, a polyethylene, a polyester, and a metal foil.

77. (Original) A method for changing a shaping or lamination process comprising:  
(a) arranging a plurality of die and anvil roller assemblies in succession along a production line;

(b) mounting the plurality of die and anvil roller assemblies on a plurality of lifting mechanisms;

(c) engaging a first portion of the plurality of die and anvil roller assemblies in production;

(d) lifting a second portion of the plurality of die and anvil roller assemblies out of service; and

(e) simultaneously raising the first portion of the plurality of die and anvil roller assemblies and lowering the second portion of the plurality of die and anvil roller assemblies.

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78. (Original) The method of claim 41, wherein the web product comprises a mastic and a film.

79. (Currently Amended) The method of claim 41, wherein the web material comprises polyester.

80. (Currently Amended) The method of claim 41, wherein the web product comprises an automotive sealant.

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